

Work Order ID 47847

June 26, 2009 7:28:01 AM



Page 1

Item ID: D3084-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Strut

Start Date: 15/07/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3084

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Punch per Dwg. D3084 and spec control dwg D2638 : Open hole to .323ø as per dwg, one side only! Debur

SB 09/07/07
M. 09/07/07

(6X)

(6)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

⇒ SB 09/07/08 (6)

120

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld ends per QSI 004. Use aluminum rod Grind flush Batch: M11311

SB 09/07/08 (6)

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Page 2

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

→ 8E 09/07/08 (6x)



QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

⇒ 8 09/07/08 (6x)



QC

Memo

0.00

Quality Control

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:10am OVEN TEMPERATURE:

7:40am FINISH TIME:

320°F

M112148

JP

09-08-09 (6x)

Work Order ID 47847

June 26, 2009 7:28:01 AM



Page 3

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

09-07-9

6

BR



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location 271

0.00

9/1/9

Sif @ 6x



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

09/07/09 HJ



QC

Memo

0.00

Quality Control

W 09-07-09

Picklist Print

June 26, 2009 7:28:00 AM

Page 1

Work Order ID: 47847

Parent Item: D3084-1RevA

Parent Item Name: Strut



Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.750W.058		Purchased	No			100	f	0.0000	19.9996			
												
6061-T6 RD Tube .750 x.058W												

M10099 SB 09/07/09 (6)

Date: Monday, 11/05/2009 1:21:00 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 47847	
Estimate Number : 11557	
P.O. Number :	Part Number : D30841
This Issue : 11/05/2009 S.O. No. :	Drawing Number : D3084 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 47295	Material :
Written By :	Due Date : 22/05/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JUD 09.05.11</u>	
Comment : Est. C 02.05.11 Added welding rod batch number NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	✓ M6061T6T0750W058	6061-T6 RD Tube .750 x.058W
-----	--------------------	-----------------------------

**Comment:** Qty.: 3.3249 f(s)/Unit Total : 19.9496 f(s)

6061-T6 Tube .750 x.058W

Material: .750 Dia X .058 wall 6061-T6(ww-t-700/6)Seamless Aluminum tubing

No: M10099

Batch

SB 09/07/07 (6)

2.0	BAND SAW	BAND SAW
-----	----------	----------

**Comment:** BAND SAW

Punch per Dwg. D3084 and spec control dwg D2638

Open hole to .323ø as per dwg, one side only

Deburr

SB 09/07/08 (6x)

M-1 09/07/08

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEP

S 09/07/08 (6)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------

**Comment:** LARGE FABRICATION RESOURCE 1

Weld ends per QSI 004. Use aluminum rod

Grind flush .

Batch: M1113111

P 09-07-08

5.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------

**Comment:** VISUAL WELDING INSPECTION

SB 09/07/08 (6x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/05/2009 1:21:00 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 47847

Part Number: D30841

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-07-08 (+6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 7:10am

OVEN TEMPERATURE: 320°F

FINISH TIME: 7:40am

09-07-09

(+6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-07-09 (+6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

✓

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

✓

Job Completion



✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

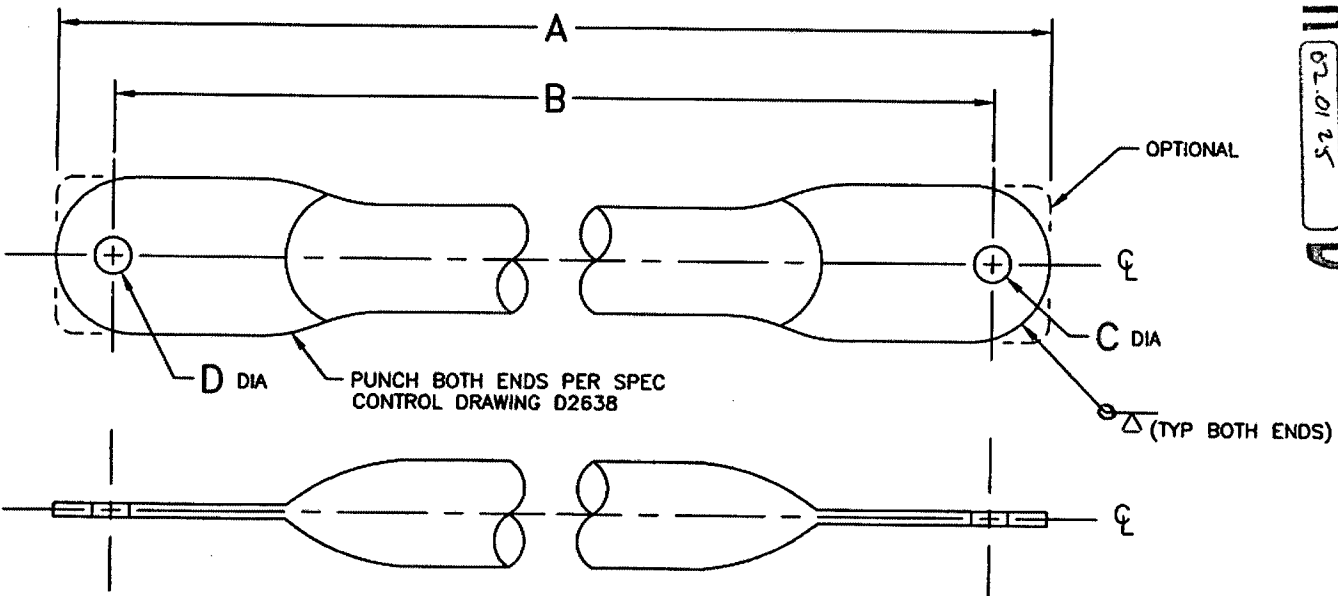
NOTE: Date & initial all entries



DART

RELEASED
62.01.25

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. A
DATE	02.01.21	TITLE	STRUT	D3084	SHEET 1 OF 1
A	02.01.21	NEW ISSUE			SCALE NTS



	A	B	C	D
D3084-1	37.18	36.38	0.257	0.323

NOTES:

1. MAKE PER TEMPLATE DT3084-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: 6061-T6 (WW-T-700/6) SEAMLESS TUBE Ø0.750 x 0.058 WALL
3. WELD ENDS PER DART QSI 004 AND GRIND FLUSH
4. FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
5. TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
6. ALL DIMENSIONS ARE IN INCHES

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WORK ORDER

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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DJD	APPROVED KE	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/07/05 KE

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8117

REFERENCE ONLY

